

Date: Thursday, 11/15/2007 7:32:39 AM
 User: Kim Johnston

Process Sheet

51

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : X-TUBE AS 350/355 HI FWD UNDER REVIEW
 Job Number : 35729A
 Estimate Number : 12484
 P.O. Number :
 This Issue : 11/15/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D350748141
 First Issue : 11 Type : LANDING GEAR Drawing Number : D350-748-141 U/R REV D
 Previous Run : 35728A Project Number : N/A
 Drawing Revision : 07/11/15
 Material :
 Due Date : 12/21/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 06-07-05 JLM
 Est Rev: B Update cadplate process 06-09-12 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-141 CHG001

N/A JA

2.0 D6017115 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

D6017-115

2.339" OD X 2.000" ID

Batch: 327471

BG 07.11.30 (1)

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

BG 07.11.30 (1)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 07.11.30 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 7:32:39 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 35729A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA648

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

3-Scribe Part & Batch as per Dwg D350-748-141

BL 07.11.30

①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BL 07.11.30

②

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/12/01

①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1

AWM
07-12-04

Comment: LANDING GEAR RESOURCE 1

Remove all Machining Marks

9.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 5266

C207/12/12

①

Heat Treat to min 180 KSI As per Dwg D350-748-141

(MIL-T-6736 OR AMS 2759-1C)

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformaty is attached

C 8/1/10

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 35729A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/01/11 EL

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT. N/A EL/JO 8-1-17

13.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

S 08-21-11

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs,
Set-up drill table as per QSI 010

EL 8-2-22

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-141

AWM 8-2-27

4-Remove all marks from tube within limits of D350-748-141

5- Apply a light coat of LPS3 on the interior of tube

Batch: M 10 5005

M-L 08/03/04 (K)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CHECK 10 DEG HOLES WITH DT8876E(EUROCOPTER CLAMP)

S 08/03/04 EL

16.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 5847

C 08/03/07 (K)

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 35729A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

Ensure Certificate of Conformity is attached

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

PS 8/4/4 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/02 (1)

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2 *RT 08-04-08*2-Prime Outside of Tube as per Dart QSI 005 4.2 *RT 08-04-08*

20.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

*ml 08 04 09**(1)*

21.0

D35021

SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SUPPORT

Batch: *32205**ml 08 04 09*

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: *35900**ml 08 04 09*

23.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: *100621**ml 08 04 09*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 8:52:42 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	X-TUBE AS 350/355 HI FWD UNDER REVIEW
Job Number :	35729A		
Estimate Number :	12484		
P.O. Number :		Part Number :	D350748141
This Issue :	04/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D350-748-141 U/R
First Issue :	15/11/2007	Project Number :	N/A
Previous Run :	35728A	Drawing Revision :	C
		Material :	
Written By :		Due Date :	21/12/2007
Checked & Approved By :		Qty:	1
Comment :	Est Rev: A New Issue 06-07-05 JLM Est Rev: B Update cadplate process 06-09-12 KJ		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abraison strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

REFERENCE ONLY

Job Completion



Date: Thursday, 11/15/2007 7:32:39 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 35729A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 107534

ml 08 04 09

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 106484

ml 08 04 09

26.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 18836

ml 08 04 09

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035. -

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

ml 08 04 09 (1)

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 08/04/10 (2)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-241

Location: PPA

PPP Rev: 35729

08/04/11 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 35729A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/15 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35729A
Description: Crosstube Assembly (AS350/355 High Fwd)		Part Number:	D350-748-141
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

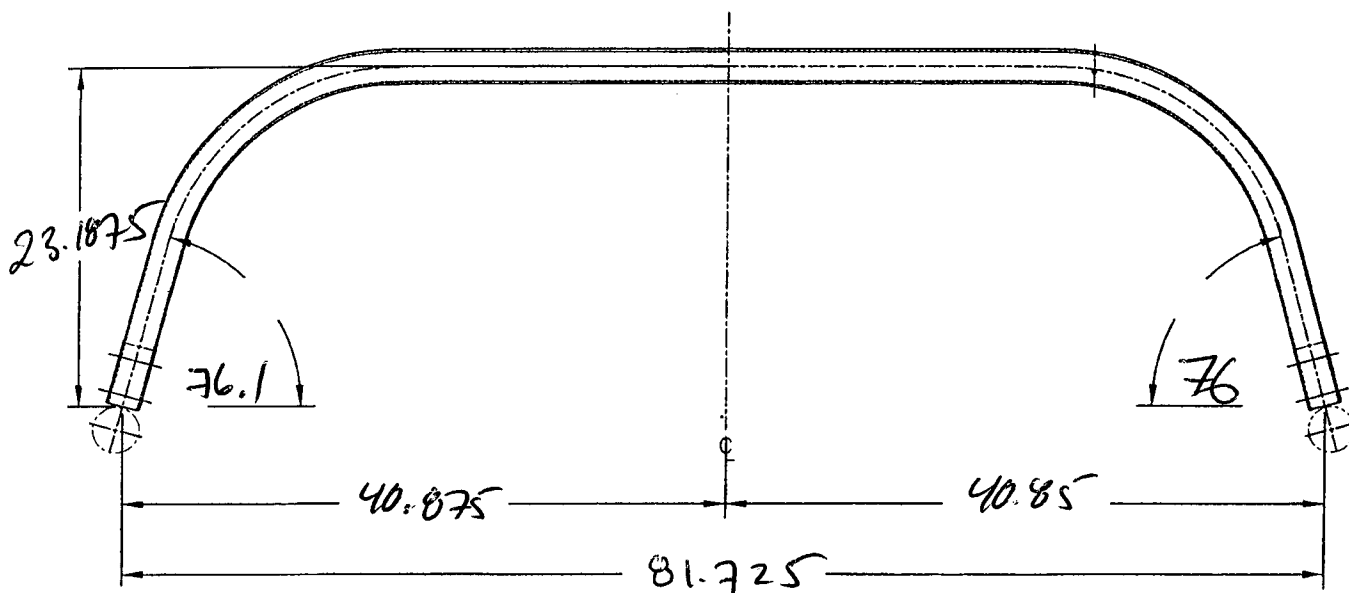
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244				
	2.180	+0.005/-0.000	2.184				
	2.180	+0.005/-0.000	2.184				
	2.237	+0.005/-0.000	2.241				
	2.272	+0.005/-0.000	2.274				
	2.306	+0.005/-0.000	2.308				
	2.339	+0.005/-0.000	2.343				
	2.339	+0.005/-0.000	2.343				
	0.062	+/-0.010	.062				
	4.26	+/-0.030	4.26				
	R0.063	+/-0.010	.063				
	R0.50	+/-0.030	.50				
SIDE B	2.240	+0.005/-0.000	2.244				
	2.180	+0.005/-0.000	2.184				
	2.180	+0.005/-0.000	2.184				
	2.237	+0.005/-0.000	2.241				
	2.272	+0.005/-0.000	2.274				
	2.306	+0.005/-0.000	2.308				
	2.339	+0.005/-0.000	2.343				
	2.339	+0.005/-0.000	2.343				
	0.062	+/-0.010	.062				
	4.26	+/-0.030	4.26				
	R0.063	+/-0.010	.063				
	R0.50	+/-0.030	.50				
	110.27	+/-0.060	110.30				

Measured by:	BE	Audited by:	J.F.	Prototype Approval:	N/A
Date:	07-11-30	Date:	07/12/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	

DART AEROSPACE LTD		Work Order:	35729A
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments

QC15 Inspection	<i>[Signature]</i> 06.02.21
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART

RELEASED

06.10.31

DESIGN 92	DRAWN BY 92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

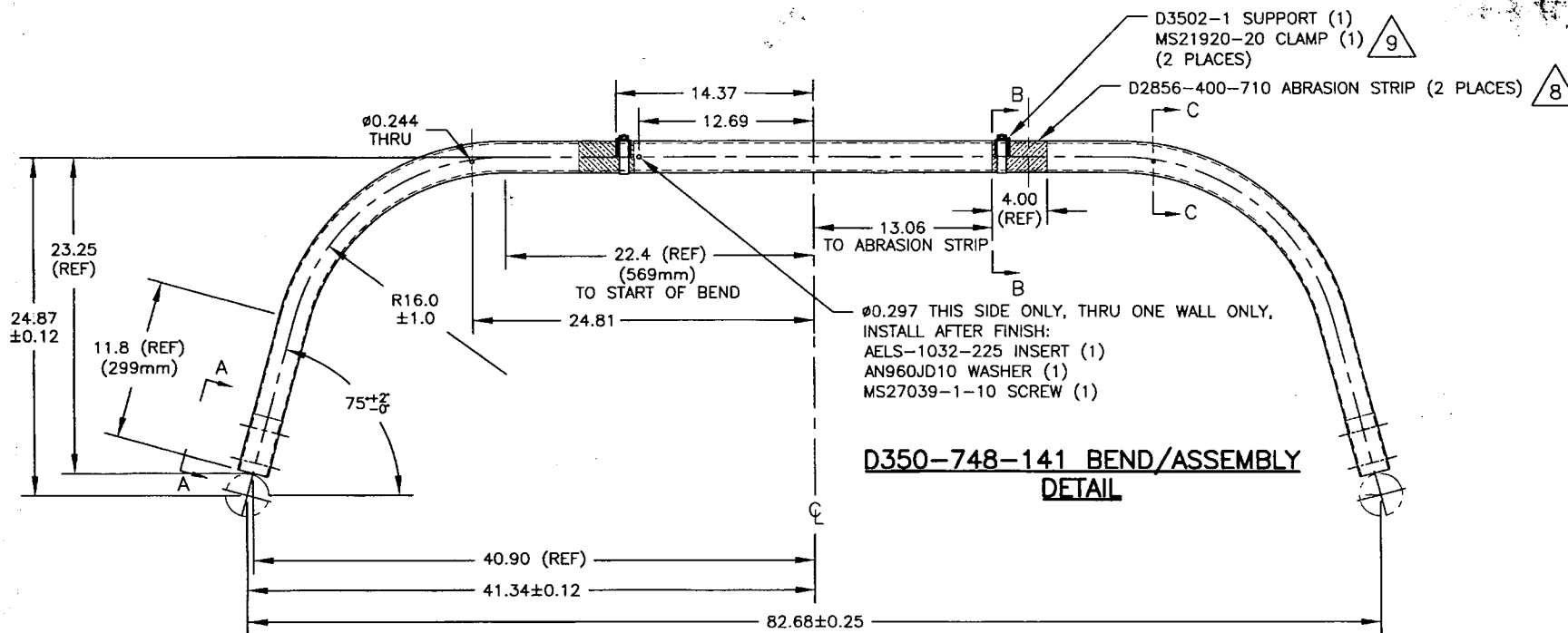
D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27 ± 0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR $\varnothing 0.297$ HOLE.

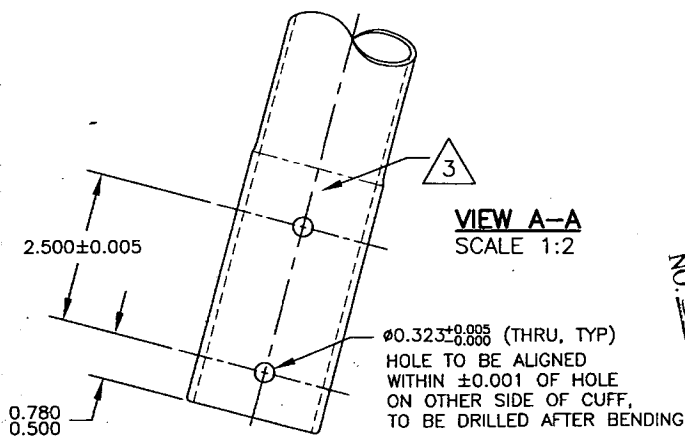
UNDER REVIEW!07.07/16
CUT OFF REDUCED
OK 10.7.22

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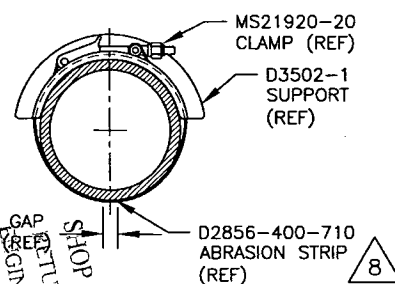
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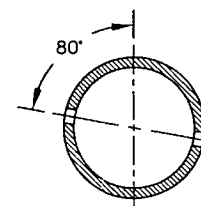
**D350-748-141 BEND/ASSEMBLY
DETAIL**



**SECTION B-B
SCALE 1:2**



**SECTION C-C
SCALE 1:2**



UNDER REVIEW!
07.02/16/17
06.10.31

RELEASED
06.10.31

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 357294

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DESIGN	97	DRAWN BY	97	DART	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED	H	APPROVED	H	DRAWING NO.	REV. D
DATE	06.10.31			D350-748-141	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE (AS 350/355 HI FWD)	1:8

5



VAC AERO
INTERNATIONAL INC.

RELEASE NOT

GST No.: R105468102

OAK 94195-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7488



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

01/07/2008

MM / DD / YYYY

PAGE: 1

BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

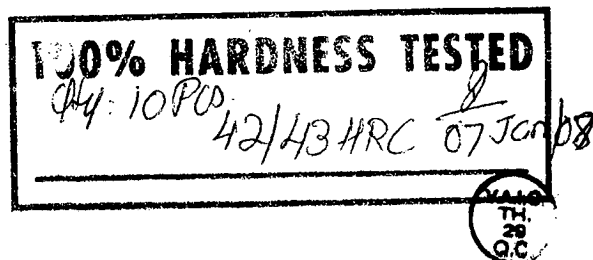
SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
01/07/2008		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
5266		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141	EA	10	10	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1D 100% HARDNESS CHECKED AS PER ASTM E-18 HRC 40-45 MATERIAL: 4130 SAND BLASTED</p> <p>D350748141B357-27A, 28A, 29A, 30A, 31A D350748241B357-32A, 33A, 34A, 35A, 36A</p> <p>NOTE: NO SERIAL NUMBERS FOUND ON PARTS</p>					



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



HEAT
TREATING

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Mar-29-2008

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 74715

INVOICE #: 38606

**CONTRACT OR
PURCHASE ORDER #** 5847

DESCRIPTION: SKID

QTY 1

P/N # D350748141

S/N # B35729A

**CADMIUM PLATE IAW AMS-QQ-P-416 TYPE 2 CLASS 1. MPI IAW
ASTM-E-1444. HEAT CHART #8933 & #8983.**

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:

William Marozzese

